

Work Order ID 70022

Wednesday, May 25, 2011 12:37:27 PM

Page 1

Item ID: D3393-041

Accept

Revision ID:

Item Name: Battery Lock Assembly

Start Date: 5/25/2011 Start Qty: 8.00

Required Date: 5/27/2011 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3393

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 12-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5 13-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten

SB 11/6/22

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Tack Weld lock shaft to flat cam of a Max 1/8" Long. QtyPart Number Description Batch# A/RN/A SS Rod 115928

120

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

7

PJO

11.05.27

7x

11.05.27

7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3393-041 PAR #: N/A Fault Category: Supplier M/MASTER NCR: Yes No DQA: 11 Date: 11.06.01
11/06/01 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 11/06/01

NCR: <u>70022</u>		WORK ORDER NON-CONFORMANCE (NCR) <u># 5.60</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/05/01</u>	<u>100</u>	<u>1 Key to turn didn't</u> <u>turn + 1 wasn't good</u> <u>R.C. Sulphur / Pusher Product.</u>	<u>11.05.26</u>	<u>Scrap + destroy</u> <u>D3373-1</u>	<u>SB</u> <u>11/05/24</u>	<u>S</u> <u>11/05/30</u>	<u>11.05.26</u> <u>Q5102</u>	<u>S</u> <u>11/05/30</u>

NOTE: Date & initial all entries

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Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Apply Crazy Glue to cap and press into Body
Batch: 1116244

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: 487

Memo

0.00

0.00



Cust Item ID:

Customer:



E/B 11/05/27

8 w/lost 30

(X7)

11/5/30 (70 SF)

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Item ID: D3393-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Battery Lock Assembly

Start Date: 5/25/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/31

ME
11-05-30

Picklist Print

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Work Order ID: 70022

Parent Item: D3393-041

Parent Item Name: Battery Lock Assembly



Start Date: 5/25/2011

Required Date: 5/27/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

5/16WC		Purchased	No			100	Each	3,379.000	2	16			
SS Flat Washer 5/16 FW516S1													

Location	Loc Qty	Loc Code
st376	2000	
117332	2000	
ST377	1379	
115072	100	
115174	57	
116643	1222	

9567K21		Purchased	No			100	Each	41.0000	2	16			
Polyethelene Cap													

Location	Loc Qty	Loc Code
ST380	41	
110822	41	

D2728-7		Manufactured	No			100	Each	0.0000	0	0			
Dart Logo label													

D3373-1		Manufactured	No			100	Each	17.0000	1	8			
Cam Lock													

Location	Loc Qty	Loc Code
ST049	17	
58463	17	

Picklist Print

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Work Order ID: 70022

Parent Item: D3393-041

Parent Item Name: Battery Lock Assembly

Start Date: 5/25/2011

Required Date: 5/27/2011

Start Qty: 8.00

Required Qty: 8.00

D3393-1

Manufactured No

100 Each

10.0000 1

8



Battery Lock Casing



JB 11/05/30

Location

Loc Qty

Loc Code

ST487

10

62953

10

D3393-3

Manufactured No

140 Each

7.0000 1

8



Cam Lock Shaft



JB 11/05/30

Location

Loc Qty

Loc Code

ST052

7

61947

7

7

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Shop Packet Print

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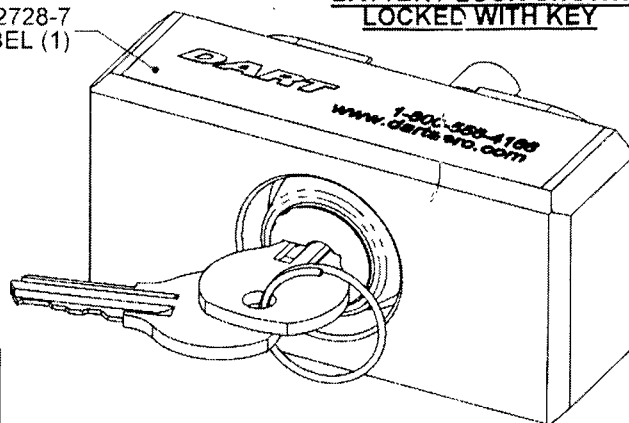
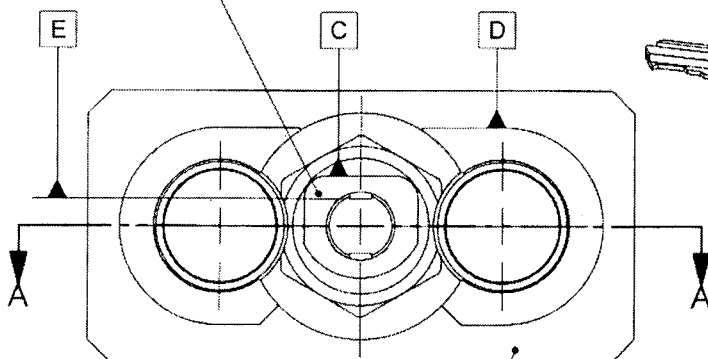
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
10/2/09

BATTERY LOCK SHOWN
LOCKED WITH KEY

D2728-7
LABEL (1)

POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWN



D3373-1
CAM LOCK
ASSEMBLY (1)

D3393-1
CASING (1)

Ø5/16" WC S/S
WASHER (1/2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) AND APPLY KRAZY GLUE

D3393-3 CAM
LOCK SHAFT (1)

0.09^{+0.03}_{-0.01} (2 PLACES)

TACK WELD
D3393-3 TO D3369-5

SECTION A-A

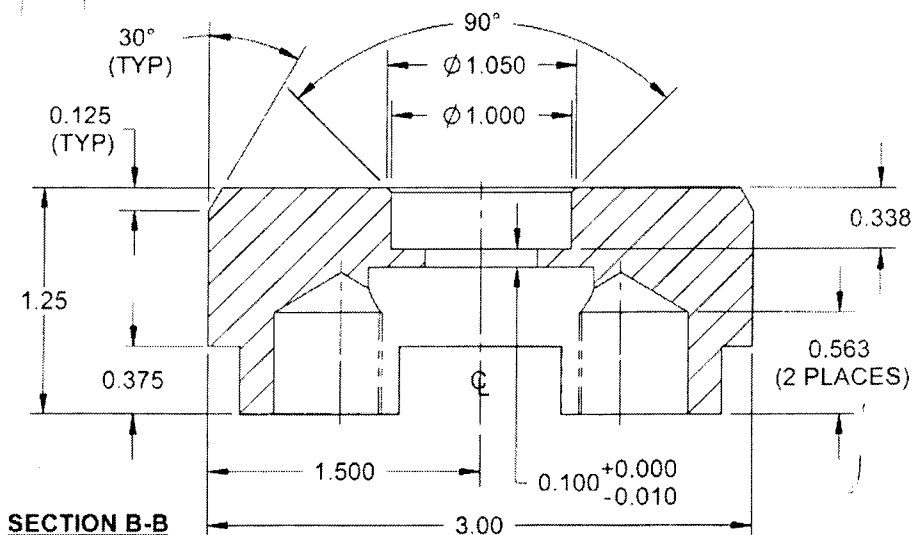
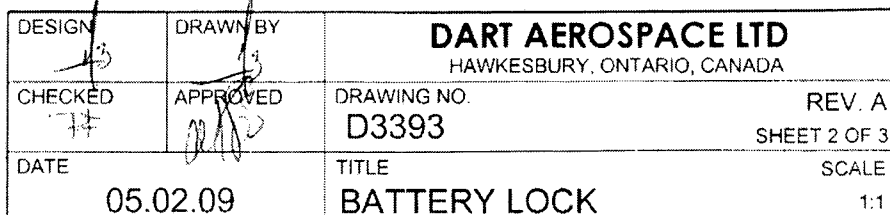
D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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NOTES:

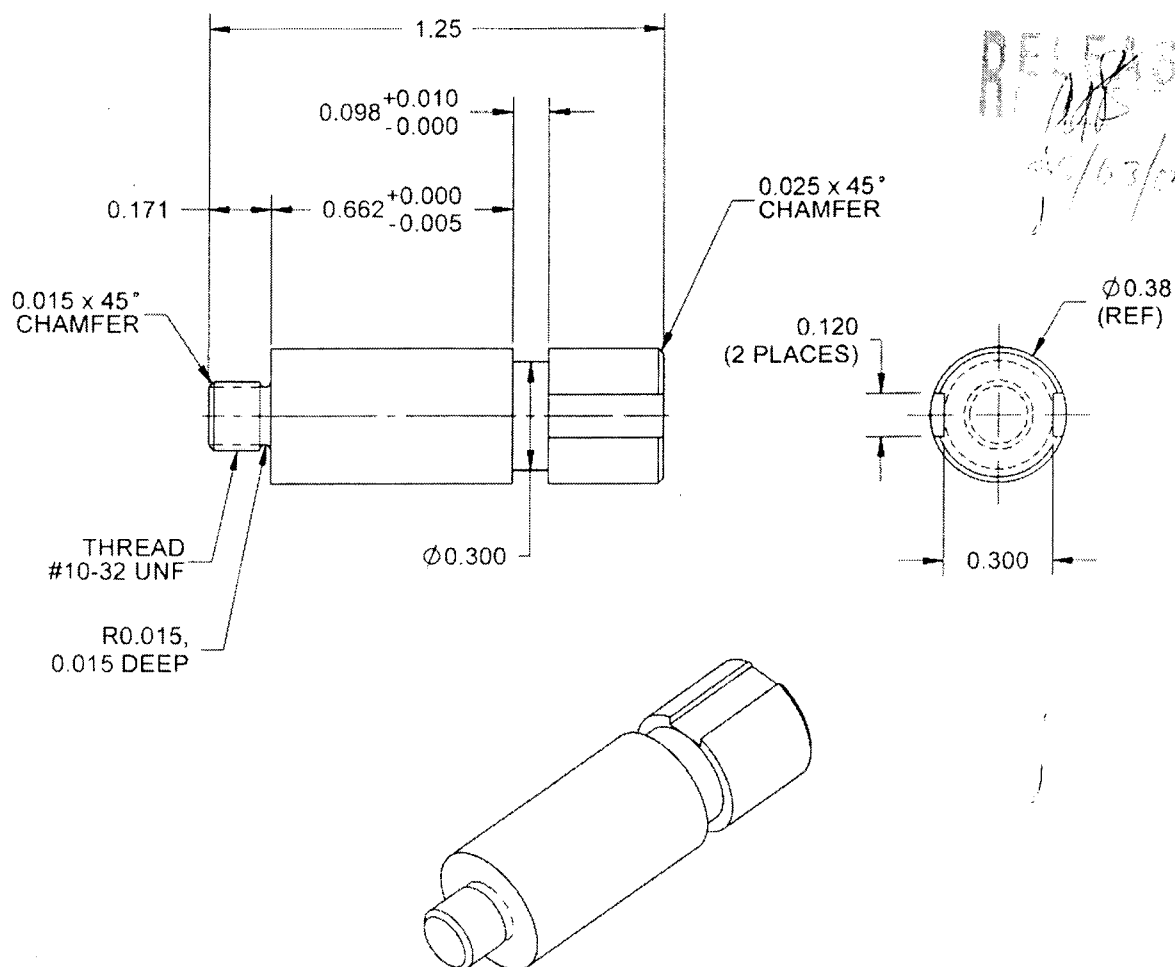
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 7F	APPROVED 11/13	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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